

Date: Monday, 12/01/2009 2:30:34 PM
User: Julie Dawson

Customer: CU-DAR001 Dart Helicopters Services

Process Sheet

Drawing Name: BACK PANEL

Job Number: 44565

Part Number: D30231

Job Number:



Seq. #:

Machine Or Operation:

Description :

2-form edge of back pan as per dwg D3023 using D3017-041 back frame

EL

9-6-22

6.0 QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

509/06/23 (X)

7.0 HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

UMP 09/06/24

8.0 POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat Grey Sandtex (Ref: 4.3.5.6) as per QSI 005 4.3

M109091

START TIME: 11:30AM

OVEN TEMPERATURE: 320°F

FINISH TIME: 12:00PM

44

09-06-24

(X)

9.0 QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

PL 09-06-24 (X)

10.0 PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: _____

9/6/24

(X)

31

11.0 QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

09/06/24 (X)

Job Completion



W 09-06-24

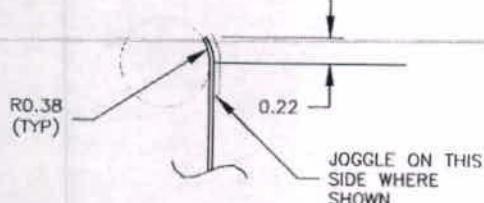
DART AEROSPACE LTD	Work Order:	WHS65
Description: Back Panel	Part Number:	D3023-1
Inspection Dwg: D3023	Rev: A	Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

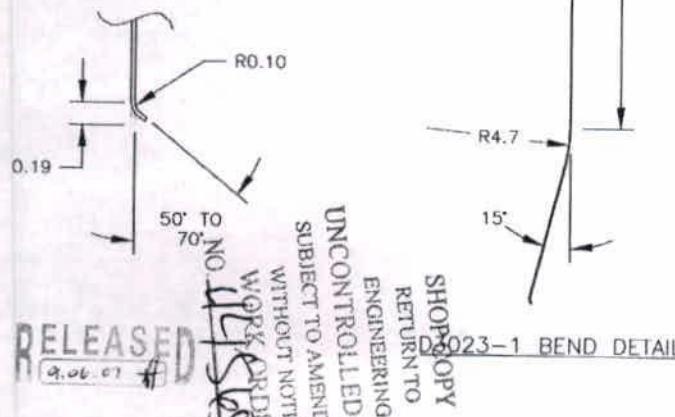
First Article Prototype

Measured by:	RB	Audited by:	S	Prototype Approval:	N/A
Date:	9-2-16	Date:	9/6/16	Date:	N/A
Rev	Date	Change		Revised by	Approved
A	08.11.27	New Issue		KJ/EC	DA

SECTION A-A
SCALE 1:1
(TYPICAL, EXCEPT WHERE SHOWN)



SECTION B-B
SCALE 1:1
(BOTTOM EDGE ONLY)

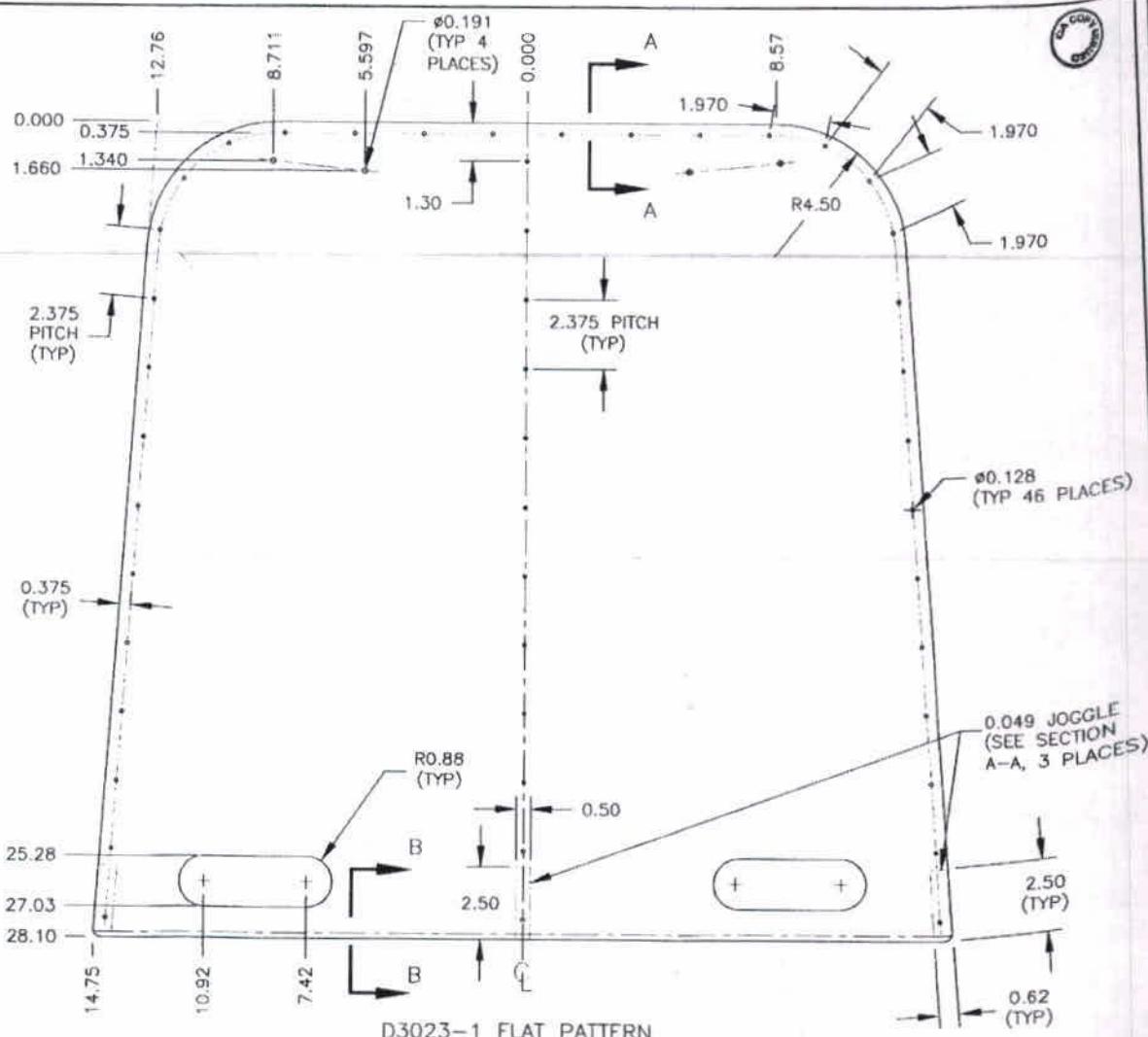


RELEASED
06/06/07

D3023-1 BACK PANEL:
1) MATERIAL: 2024-T3 (QQ-A-250/4) 0.035" THICK
2) FINISH: ACID ETCH & ALODINE PER DART QSI 005 4.1
POWDER COAT GREY SANTEX (REF 4.3.5.6) PER DART QSI 005 4.3
3) ALL DIMENSIONS ARE IN INCHES.
4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED.

WORK ORDER
ENGINEERING
RETURN TO
SHOP COPY

UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE



D3023-1 FLAT PATTERN

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DART AEROSPACE LTD.

A		01.05.18	NEW ISSUE
DESIGN	DRAWN BY	DART	
CHECKED	APPROVED	DRAWING NO.	D3023
DATE		TITLE	BACK PANEL
01.05.18			

DART AEROSPACE LTD.
HAWTHORPE, ONTARIO, CANADA
REV. 1
SHEET 1 OF
SCAL 1: